

Date: Tuesday, 21/04/2009 2:10:54 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG  
 Job Number : 47335  
 Estimate Number : 11683  
 P.O. Number :  
 This Issue : 21/04/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D2888  
 First Issue : 1/1 Type : MACHINED PARTS Drawing Number : D2888 REV A2  
 Previous Run : 46688 Drawing Revision : A  
 Written By : SL/09/04/21 Material :  
 Checked & Approved By : Due Date : 30/04/2009 Qty: 20 Um: Each  
 Comment : Est. C 00.06.22 Removed P/O for powder coat EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X03500 6061-T6 Bar 2.50 x 3.50



Comment: Qty.: 0.3938 f(s)/Unit Total : 4.7250 f(s)

6061-T6 Bar 2.5" x 3.5"

Material: 3.5" x 2.5" bar 6061-T6

Batch: 111700 SL 09/05/29 (20)

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 4.20" long

( Grain along 4.20" )

SL 09/05/29 (20)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2888

Deburr and Tumble

SL / H.A 09/05/29

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SL / H.A 09/05/29

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SL 09/05/01

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 47335

Part Number: D2888

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

umd 09/06/01

(420)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m 111472

START TIME:

7:35

OVEN TEMPERATURE:

320°

FINISH TIME:

8:05

FL 09/06/02

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BP 09-06-2

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST480

SS 09/06/02

(20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02

Job Completion



MF  
09-06-02

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47335
<b>Description:</b> Lug		<b>Part Number:</b> D2888
<b>Inspection Dwg:</b> D2888	<b>Rev:</b> A2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

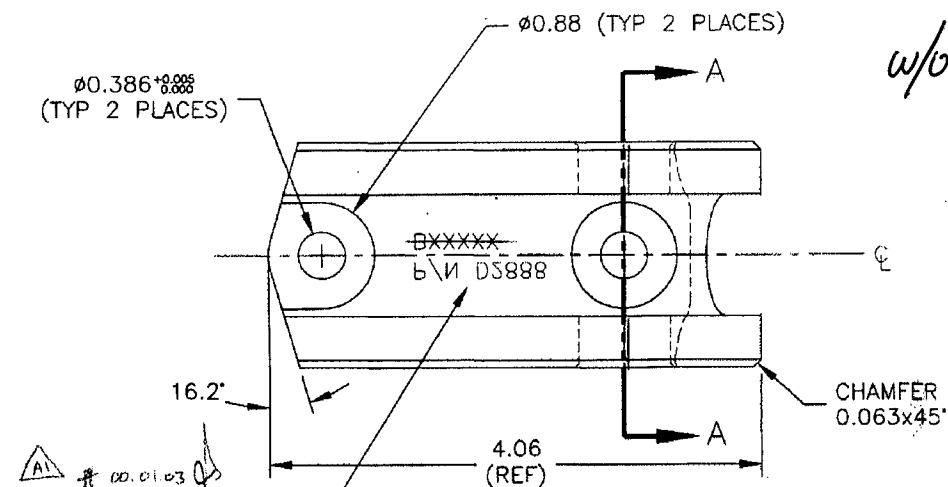
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.386	+0.005/-0.000	Ø0.389	✓			
Ø0.88	+/-0.030	Ø0.875	✓			
0.063 x 45°	+/-0.010	0.060x45°	✓			
4.06	+/-0.030	4.054	✓			
Ø0.760	+0.005/-0.000	Ø0.761	✓			
3.48	+/-0.030	3.480	✓			
2.500	+/-0.010	2.501	✓			
2.75	+/-0.030	2.750	✓			
0.438	+/-0.010	0.4345	✓			
0.080 x 45°	+/-0.010	0.080x45°	✓			
1.85	+/-0.030	1.8495	✓			
1.000	+/-0.010	1.0045	✓			
0.425	+/-0.010	0.423	✓			
0.030 x 45°	+/-0.010	0.030x45°	✓			
1.875	+/-0.010	1.881	✓			
0.375	+/-0.010	0.370	✓			
R0.25	+/-0.030	R0.250	✓			
1.29	+/-0.030	1.290	✓			
0.414	+/-0.010	0.412	✓			
3.41	+/-0.030	3.409	✓			

<b>Measured by:</b> G.A
<b>Date:</b> 09/05/29

<b>Audited by:</b> SP
<b>Date:</b> 09/06/01

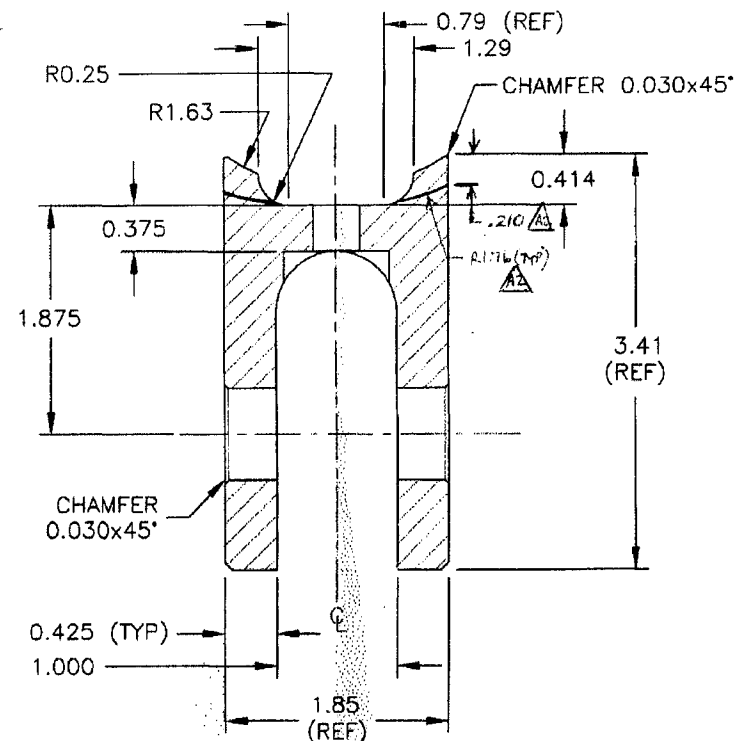
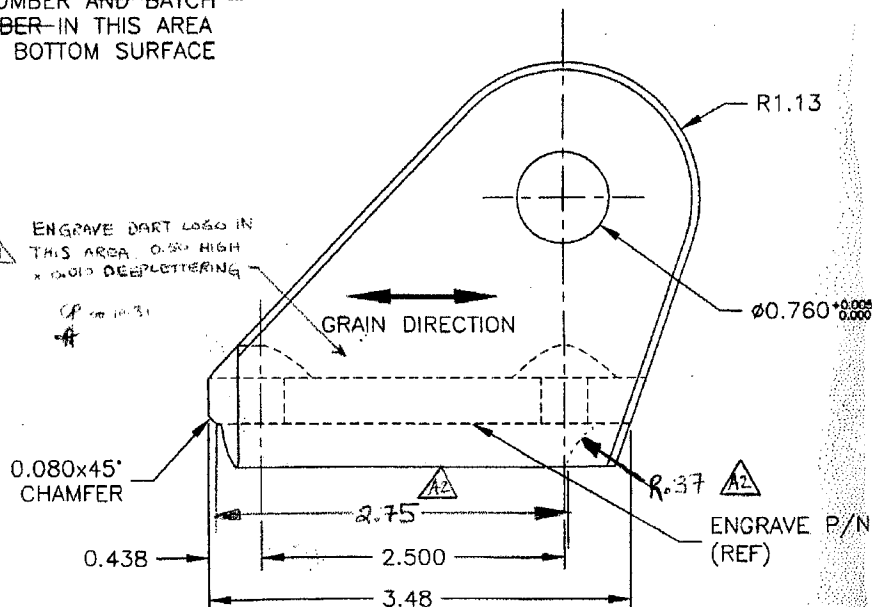
<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.06.04	New Issue	KJ/DD	



ENGRAVE DART PART NUMBER AND BATCH NUMBER IN THIS AREA ON BOTTOM SURFACE

ENGRAVE DART LOGO IN THIS AREA 0.010 HIGH x 0.010 DEEPLITERING



SECTION A-A  
SCALE 1:1

RELEASED  
99.07.09 05

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
BREAK UNMARKED EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

A2	04.04.08	Add Saddle Clearance for NCR 784
A1	20.10.31	Update Engraving

A	99.06.21	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2888
DATE	99.06.21	TITLE LUG